Date

Wednesday, 2/20/2008 4:14:41 PM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 37508 **Estimate Number**

: 10891

P.O. Number

: 2/20/2008 This Issue Prsht Rev.

: NC

First Issue Previous Run

: 11

: 29912

Type

S.O. No. :

: SMALL /MED FAB

Drawing Number Project Number

Drawing Name

Part Number

Drawing Revision

Material

Due Date

: 3/3/2008

: N/A

: A

: D32581

. D3258 REV A

: ANGLE BRACKET

Qty:

6 Um:

Each

Written By

Checked & Approved By

Comment

: Est

Added Steps 6-7 KJ/JLM

Est Rev:C Now on Waterjet 06-12-13 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304S16GA

Comment: Qty.:

304/316 .063 Sheet 16 Gauge

0.0053 sf(s)/Unit

Total:

0.0315 sf(s)

Batch:

106860

8-2-33

2.0

WATER JET

FLOW WATER JET

304/316 .063 Sheet



Comment: FLOW WATER JET

1-Cut as per Dwg D3258

Dwg Rev:

Prog Rev:_



2-Deburr if necessary

INSPECT PARTS AS THEY COME OFF MACHINE

3.0

QC2



EC-C-8 8



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

Comment: SECOND CHECK

BRAKE NC

SECOND CHECK



5.0

NC BRAKE



Comment: NC BRAKE

- Deburr if necessary Form as per Dwg D3258 08/03/03

Form: rorocess

Page 1

Dart Aerospace Ltd

Dail Ac	rospace Liu							
W/O:			WORK ORDER	CHANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Category:	NCR: Yes	No DQ	A: <u>Q</u>	Date: <u>_</u>	20/03/11
				QA:	N/C Close	d:	_ Date: _	
NCR:			WORK ORDER NON-COM	IFORMANCE (NO	R)		·	
							r	T

				CE (NCR)			
	Description of NC		Corrective Action Section B		Verification	Approval	Annroyal
TEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspecto
T!	EP .	EP Description of NC Section A	EP Description of NC Section A Initial	Section A Initial Action Description	EP Section A Initial Action Description Sign &	EP Section A Initial Action Description Sign & Section C	EP Section A Initial Action Description Sign & Verification Approval

NOTE: Date & initial all entries

Wednesday, 2/20/2008 4:14:42 PM User: Kim Johnston **Process Sheet** Drawing Name: ANGLE BRACKET Customer: CU-DAR001 Dart Helicopters Services Part Number: D32581 Job Number: 37508 Job Number: Seq. #: Description: Machine Or Operation: INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 Comment: FINAL INSPECTION/W/O RELEASE mi 2008/3/04 Job Completion

Dart Aerospace

Dart Ae	rospace L	.la							
W/O:			WORK	ORDER CH	ANGES				
DATE	STEP	PRO	OCEDURE CHANGE			Ву	Date (Approv Chief Eng Prod Mg	/ Approva
Part No		PAR #:	Fault Category:		NC	R: Yes	No DQA:	Date	
						QA: N	/C Closed: _	Date	
NCR:			WORK ORDER N	ION-CONFC	PRMANCE	(NCR			
		Description of NC	Corre	ective Action	Section B		Verificati	on Approv	al Approval
DATE	STEP	Section A	Initial	Action Descrip	otion	Sign &	Section (,	

NCR:		,	WORK ORDI	ER NON-CONFORMANO	CE (NCR)	•					
		Description of NC	Corrective Action Section B			Verification	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspecto			
								,			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37508
Description: Angle Bracket	Part Number:	D3258-1
Inspection Dwg: D3258 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

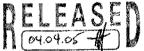
Prototype х **First Article** Actual **Drawing** Method of Accept Reject Comments **Tolerance** Inspection Dimension **Dimension** 0.500 +/-0.010 +/-0.010 1.050 0.250 +/-0.010 606, 0.202 +/-0.010 1.454 +/-0.010 +0.005/-0.001 ¥ Ø0.206 00G +/-0.010 261, R0.125 X

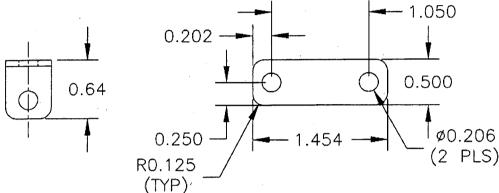
Measured by:	R	Audited by:		Prototype Approval:	N/A
Date:	8-2-92	Date:	080227	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.01.17	New Issue	KJ/JLM	

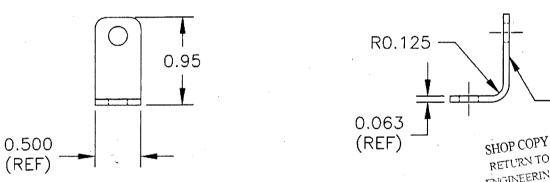


DESIGN	RF	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAI	
CHECK	ED /	APPROYED	DRAWING NO.	REV. A
	A	19	D3258	SHEET 1 OF 1
DATE			TITLE	SCALE
04.0	1.27		ANGLE BRACKET	1:1
 Α		04.01.27	NEW ISSUE	

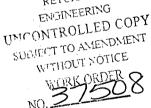




D3258-1 FLAT PATTERN



D3258-1 ANGLE BRACKET



- 1) BREAK ALL SHARP EDGES 0.005 to 0.015
- 2) MATERIAL: AISI 304/316 SS 0.063 (16 GAUGE) THICK (REF. DART SPEC. M304S16GA)
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE DART P/N AS SHOWN

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.